Work Orde				*107	7853*							Page 1	
Revision ID:	D3189-1 Chaffing Shi	eld		Accept	*N900	040	100)*	Setup S	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	10/03/13 10/17/13	Start Qty: 20 Req'd Qty: 20	7 ()		Cust Item Customer:	ID:							
Approvals:			Date: /3-/0-0			ate:				Start Stop		R1* R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr		THE SECOND SECON									
D3189	C		 '										
100				0.00									
100 Waterjet		SHEAR Mem	0	0.00				20	<u> </u>	<u>. </u>		Jn13-10-8	Э.
FLOW CNC Waterje	et	Dwg Prog I	t as per Dwg Rev: Rev: burr if necessary										
103		QC2- Inspect parts	s off machine FAI/FAIB	0.00									
103		Mem	0	0:00				20	_O	:	And Angles	JMB-10-8	9,

Quality Control

Pro

NCR:	Voc	1	No
NCK:	Yes	/	INO

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: <u>(</u>	Suff	Date:	13/11/22	
) Classel	OKI	- Data:	13/11/15	

										QA Closeu.	VIII4 Date.	
Work Order:	10	783	3		DISPOSITION				AGAINST DE	PARTMENT	<u></u>	
Part No.	13-	189-1	/		Rework Scrap Use-as-is Work Order Update	ТН	N herm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet 52. d. Eng. Coor. re/Packaging Supplier	Engineering 🛪 Quality Other
Root				Descri	ption of work order update	Initi	al	Act	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	-	100	20	7561	A MATIL NOT	02 12 9-80	9	Acceptable ue 24	ie to	DAS 12 989	DAS 27 9-89	DAS 16 9-89
Material % Setup Other Process				RC may	-ABLE.	13/10/7	18	We 24.	4A	13/10/23	86018	13/11/py
Supplier Training Unapproved												
					F	AULT C	ATEG	ORY	-			
Landing	Gear				General					_	_	-
	Bending Centre N Cracks	ot Conce	ntric to	o/s	Bend BOM/Route Broken/Damaged	\vdash	rdwar	re on Incomplete		Ovalized Over/Under Part Incorre		Pressure/Forced Temperature/Cure Weld
	Crushed/	Crimped			Burrs	Ins	tructi	ons Incomplete/I	Unclear	Part Lost/M	· ·	Wrong Stock Pulled
	Cuffs				Contamination	ШМа	ainter	nance	<u> </u>	Part Moved		
	Heat Trea			L	Countersink	\vdash	slabel		<u> </u>	Positioned \		7
	Inspectio	•	Tube		Cut Too Short	\vdash	sread			Power Loss/		Other
	Ripples in				Drill Holes	\vdash	fset					purchase
	Torque V			n _	Drawing	-		alibration		DRAWY	ARE WROY	
	Turning			-	Finish	\vdash		equence				
1	Mayo/Tu	uct in Tu	ha		Icolio	I IOu	steida	Dimensions				

Work Orde		7853		†	'1 07	853	*							Page 2
Item ID: Revision ID:	D3189-1			Accept	· · · · · · · · · · · · · · · ·	*NC	ลดด	<u>040</u>	100)*	Setup	Start Stop	171.	S1*
	Chaffing Shiel 10/03/13 10/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*				t Item I tomer:	ID:				Stop	*N:	S2*
Approvals:		n:	Date:		_			ate:			Run	Start Stop	7	R1* R2*
Sequence ID/ Work Center II 105 *105* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	d check	Set Rui 0.00	Up/ Houpes 27 9-89		ool ID	Tool#	Plan Code	Accep Qty	ot Rej Qty		Reject Number	Insp. Stamp
*110 *110* Small Fab Small Fab		Small Fab Memo 1- Roll as per	Dwg D3189	0.90						20	<u> </u>			58 1310
120 *120* QC		QC5- Inspect part complete	eness to step on W/O	0.00	DAS 16 9-89	13/10/	30			470				·

Quality Control

												DQA:	Dat	te: _	
NCR:	Yes	/ No				WORK ORDER NON- 0	O	NFORM	MANCE / UP	DATE		_			
									s		(QA Closed:	Dat	te:	
Work Ord	or:			, .		DISPOSITION				AGAINST D	EΡ	ARTMENT/	PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root			T		Descri	I ption of work order update	Π	nitial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng	Desc	cription		Date	Verification	n	QC Inspector
Doc/Data											T				
Equip/Tooling															
Operator											İ				
Material								-							
Setup						•		-							
Other											1				
Process											ŀ				
Supplier							1			•	1				
Training			1								۱				
Unapproved									İ		\perp				
						F	AUI	T CATE	GORY						
Land	ing (Gear			_	General	_	,		_	_		1		
		Bending			L	Bend		Grain		_	-	Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire	<u> </u> _	_ '	Over/Under	tolerance		Temperature/Cure
1	L	Cracks			L	Broken/Damaged	L	Inspecti	ion Incomplete	L	الـ	Part Incorred	t	<u> </u>	Weld
	L	Crushed	'Crimped			Burrs	L	Instruct	tions Incomplete	/Unclear	الــ	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte			╝	Part Moved			
		Heat Tre	at			Countersink		Mislabe	eled		ال	Positioned V	Vrong		
		Inspection	n Strip in	Tube	. [Cut Too Short		Misread	d		7	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107853

107853

Page 3

October-04-13 7:26:54 AM D3189-1 Item ID: Accept *N900040100* Setup Start **Revision ID:** Chaffing Shield Item Name: **Start Qty: 20.00** *20* **Start Date:** 10/03/13 **Cust Item ID:** Required Date: 10/17/13 **Req'd Qty:** 20.00 **Customer:** Reference: Run Process Plan: Date: _____ Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Operation Reject Reject Sequence ID/ Tool 1D Set Up/ Tool # Plan Accept Insp. **Work Center ID Description Run Hours** Code Qty Oty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *120* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140

140 QC

Quality Control

Memo

0.00

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-	CON	NFORM	/ANCE / UP	DATE		D-1-	
										QA Closed:	Date:	<u>.</u>
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order.					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap	1 1	i	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR No.					Work Order Update	1 1		Large Fab	Composite		Supplier	
			*			-						
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	_		,									
Operator												
Material	_										-	
Setup	_		1									
Other	_		Į.									
Process		[
Supplier		1						,				
Training												
Unapproved												
					F	AUL	T CATE	GORY				

Landin	g Gear	General	 _	 _		-
ſ	Bending	Bend	Grain	Ovalized		Pressure/Forced
Ī	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	 Part Moved		
	Heat Treat	Countersink	Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge		Other
•	Ripples in Bend	Drill Holes	Offset			
Ī	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence		,	
	Waye/Twist in Tube	Folio	Outside Dimensions			

Picklist Print

October-04-13 7:26:58 AM

Work Order ID: 107853

Parent Item Name: Chaffing Shield

D3189-1

107853

D3189-1

Start Date: 10/03/13

Required Date: 10/17/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

Parent Item:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S2 GA	J	Purchased	No		Mark	100	sf	0.0000	0.32	(1)			
M304S25 304/316 ,020 Sheet	AGA								** .				Jm13-10-0

3#125771

125771

										DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-	100	NFOR	MANCE / UF	PDATE			
										QA Closed:	Date:	
Work Order:	•				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Order.	•				Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part No).				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No)				Work Order Update]		Large Fab	Composite		Supplier	
		,		1		T .						
Root	,				ption of work order update	1	Initial		ction	Sign &		
Cause	Date	Step	Qty	'	or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data			1	ŀ								
Equip/Tooling						Ì				E		
Operator												
Material	7									Ì		
Setup												
Other				1 .								
Process	7					1					}	
Supplier	7											
Training												
Unapproved									-			
					F	AUI	T CATE	GORY				
Landing	g Gear				General					_		_
l	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	107853
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189 Rev: C	· .	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.38	+/-0.030	4.384"	_		U	Jhmo1 Phodugoz
12.00	+/-0.030	12.007"	-		V	Phodugoz
0.020	+/-0.010	12.007"	_		V	
	Mark St. A.					

			DAS		
Measured by:	m	Audited by:	27 9-89	Preliminary Approval:	
Date: (3.10-28	Date:	Bloss	Date:	
Date.	2.10.02		131021		L

Rev	Date	Change	Revi	sed by	Approved
A	11.06.21	New Issue	KJ	Δ	3//
В	12.09.26	Dimensions updated per Dwg Rev C	KJ	7	Chl
				1 /	

										DQA:	Date:			
NCR: Y	res / No				WORK ORDER NON-CONFORMANCE / UPDATE									
					QA Closed: Date:									
Work Orde	or.				DISPOSITION AGAINST DI					PARTMENT				
Part N	No				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab				Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root	- 1	T		Descri	rtion of work order update Initial Action			ion	Sign &		T			
Cause					or Non-conformance	1	hief Eng Description			Date	Verification	QC Inspector		
Doc/Data						Ť						1		
Equip/Tooling					•		•							
Operator														
Material														
Setup						Ì								
Other														
Process		ļ	1 1											
Supplier								-		,				
Training		İ				l								
Unapproved														
					F	AUL	T CATE	GORY						
Landi	ng Gear				General		-			,	-	- 1		
	Bending				Bend	L	Grain			Ovalized		Pressure/Forced		
	Centre N	Not Conce	ntric to (D/S	BOM/Route		Hardwa	re		Over/Under	_	Temperature/Cure		
	Cracks				Broken/Damaged		4 '	on incomplete	<u> </u>	Part Incorred		Weld		
		l/Crimped			Burrs	L	4	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
,	Cuffs				Contamination		Mainte			Part Moved				
	Heat Tre				Countersink		Mislabe			Positioned V		7		
	Inspecti	on Strip ir	n Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other		
	Ripples	in Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence Wave/Twist in Tube

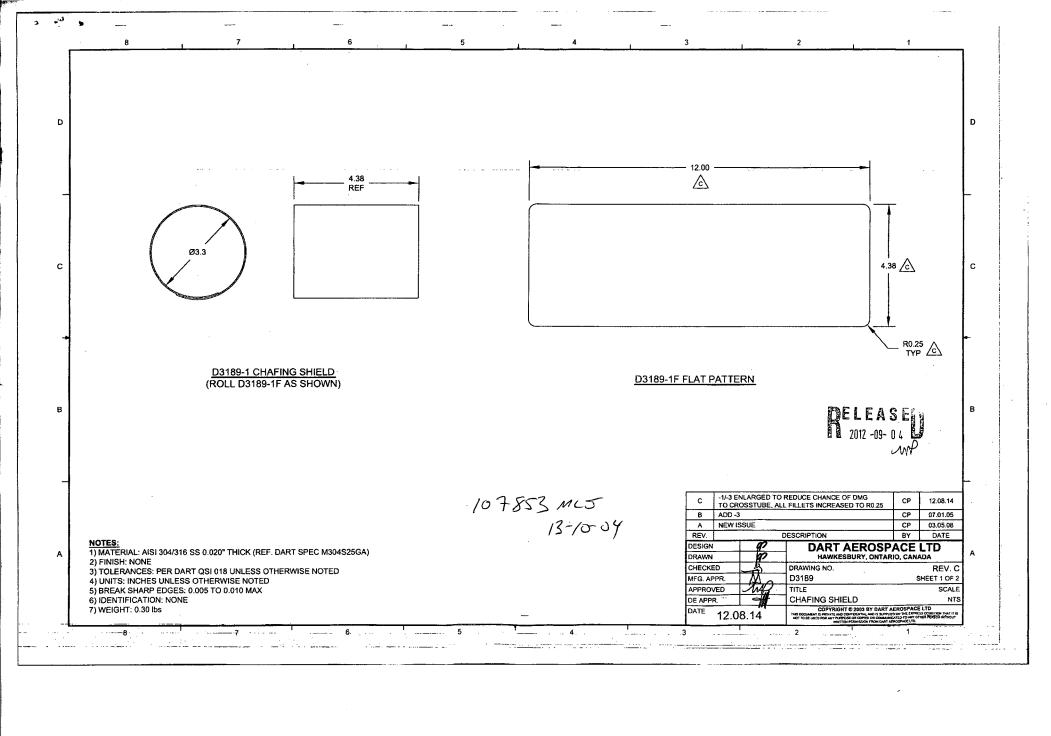
Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DC	JA: آ	Da	ite:	
NCR:	⁄es	/ No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:									-
Work Orde	o ė.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part I	۔ ِ No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier				Engineering Quality Other
Root					Descri	ption of work order update		Initial Action		ion	Sign 8	<u> </u>			
Cause	Cause Date Step Qty			or Non-conformance	Ch	nief Eng	Descr	iption	Date	,	Verification	n	QC Inspector		
Doc/Data							П								
Equip/Tooling															
Operator															
Material			1												
Setup					į										
Other															
Process															
Supplier															
Training															
Unapproved		l 					<u></u>								
						F	AUI	LT CATE	GORY						
Landi	ing (Gear				General		-			_				•
		Bending			L	Bend	L	Grain			Ovalized				Pressure/Forced
		Centre N	ot Conce	ntric to	O/S	BOM/Route		Hardwa	ire		Over/Under tolerance			Temperature/Cure	
		Cracks			<u></u>	Broken/Damaged	L	Inspect	ion Incomplete	<u> </u>	Part Inco	orrec	:t		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Los	t/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mo	ved			
	Heat Treat					Countersink		Mislabe	Mislabeled Positioned Wrong						

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

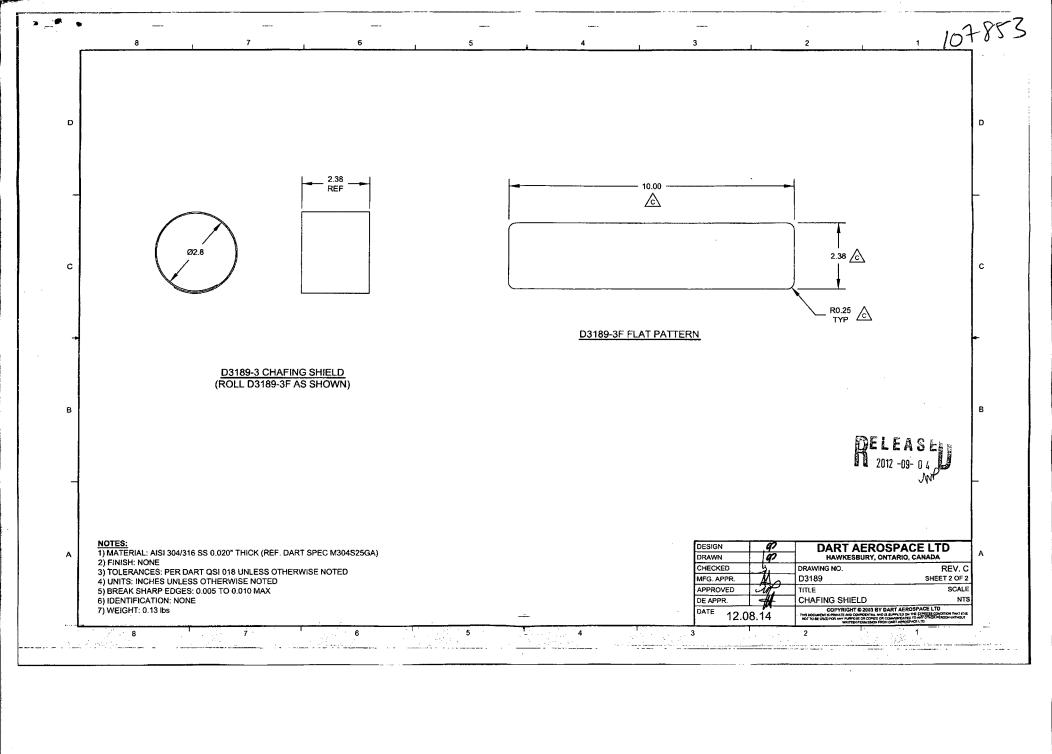
Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									DQA:	Date	·				
NCR:	⁄es	/ No				WORK ORDER NON-C	:01								
						in the second se					QA Closed:	Date	:		
Work Orde	`r.					DISPOSITION AGAINST D					DEPARTMENT/PROCESS				
WOIK OIG	-		 			Rework	Skid-tube Crosstube				Water Jet	Engineering			
Part N	۷o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•					Use-as-is		noforming	Finishing	l	re/Packaging	Other			
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier			
Root Descri				iption of work order update		Initial Action			Sign &						
Cause	e Date Step Qty or Non-con				or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector			
Doc/Data	Ш						1								
Equip/Tooling											:				
Operator						i					İ				
Material															
Setup	Ш						1								
Other															
Process	L		İ												
Supplier	<u> </u>								·						
Training	<u> </u>					•						<u> </u>			
Unapproved	<u> </u>					·	<u> </u>								
							AUL	LT CATE	GORY				<u> </u>		
Landi	ng (1			_	General	_	1			1	_	7-		
	<u> </u>	Bending				Bend	\vdash	Grain		_	Ovalized	⊢	Pressure/Forced		
	\vdash	Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure		
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	\vdash	- `	ion Incomplete		Part Incorre	 	Weld		
	\vdash	Crushed/	Crimped		<u> </u>	Burrs	_	-1	tions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled		
	\vdash	Cuffs			<u> </u>	Contamination	_	Mainte		<u> </u>	Part Moved				
	<u></u>	Heat Trea			_	Countersink	L	Mislabe		<u> </u>	Positioned V	·	-1		
1	Inspection Strip in Tube					Cut Too Short	Too Short I IMisread					Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion